

Work Order ID 59083

May 26, 2010 9:06:44 AM



Page 1

Item ID: D3913-041

Accept



Setup Start



Revision ID:

Item Name: Long Basket Base Assemby, 350

Stop



Start Date: 5/26/10 Start Qty: 1.00



Cust Item ID:

Required Date: 6/03/10 Req'd Qty: 1.00



Customer:

Reference:

Approvals: Process Plan:

Date: _____ Tooling: _____

Date: _____

Run Start



QC: _____

Date: _____ SPC (Y/N): _____

Date: _____

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr
----------	--------------

D3913	A
-------	---

100 Weld per dwg A/R S.S. rod, Batch: 100775 0.00

Large Fab

Memo 0.00

1- assemble ribs , weld as per dwg D3913 using DT9610A
 inspect before welding mesh
 2- tack weld mesh on basket as per dwg D3913 and trim mesh to fit
 3- weld hinge (3) and Mounting brackets as per dwg D3913
 take lid to locate hinge and bracket

110



QC9- Inspect visual per QSI004- Fusion Welds

0.00

QC

Memo

0.00

Quality Control

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 59083

May 26, 2010 9:06:45 AM



Page 2

Item ID: D3913-041

Accept



Setup Start



Revision ID:

Item Name: Long Basket Base Assembly, 350

Stop



Start Date: 5/26/10 Start Qty: 1.00



Cust Item ID:

Required Date: 6/03/10 Req'd Qty: 1.00



Customer:

Reference:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center ID

120



QC

Quality Control

Operation
Description

QC5- Inspect part completeness to step on W/O

Memo

Set Up/
Run Hours

0.00

0.00

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

130



Powdercoat

Powder Coating

White Gloss(Ref.4.3.5.2) per QSI005 4.3-Steel

Memo

14207

0.00

0.00

=> 10/06/01

1 9

1ST COAT:

START TIME: 8:00 am
OVEN TEMPERATURE: 100° F
FINISH TIME: 8:30 am

***** 2nd coat if necessary *****

2ND COAT: 8:30

START TIME: 100° F
OVEN TEMPERATURE: 100° F
FINISH TIME: 10:00 am

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 59083

May 26, 2010 9:06:52 AM



Page 3

Item ID: D3913-041

Accept



Setup Start



Revision ID:

Item Name: Long Basket Base Assembly, 350

Stop



Start Date: 5/26/10 Start Qty: 1.00



Cust Item ID:

Required Date: 6/03/10 Req'd Qty: 1.00



Customer:

Reference:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

140

QC3- Inspect Part Finish

0.00



QC

Memo

0.00

Quality Control

150

Assemble as per dwg

0.00



HandFinish

Memo

0.00

Hand Finishing

Pick Kit

160

QC5- Inspect part completeness to step on W/O

0.00



QC

Memo

0.00

Quality Control



W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 59083

Page 4

May 26, 2010 9:06:52 AM

Item ID: D3913-041

Accept



Setup Start



Revision ID:

Item Name: Long Basket Base Assembly, 350

Stop



Start Date: 5/26/10 Start Qty: 1.00



Cust Item ID:

Required Date: 6/03/10 Req'd Qty: 1.00



Customer:

Reference:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center ID

170



Packaging

Packaging

Operation
Description

Identify as per dwg & Stock Location:

G-A
W/O 59081Set Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

0.00

0.00

180



QC

Quality Control

QC21- Final Inspection - Work Order Release

0.00

Memo

0.00

10-6-4

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

May 26, 2010 9:06:41 AM

Page 1

Work Order ID: 59083



Parent Item: D3913-041



Parent Item Name: Long Basket Base Assemby, 350

Start Date: 5/26/10

Required Date: 6/03/10

Comments: IPP Rev:A new issue DD 10.03.19 verified by:EC
chg qty's DD 10.04.12 verified by:EC

IPP Rev:B

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D2581		Manufactured	No			100	Each	34.0000	2	2			

Mounting Bracket

Location	Loc Qty	Loc Code
WA	34	
46086	2	
51745	2	
57185	1	
58301	9	
58687	20	

D3913-1



Manufactured No

100 Each 0.0000 1

PD 10.06.01

Rib

D3913-15



Manufactured No

100 Each 10.0000 1

PD 10.06.01
BS3741-5(1)

Wide Handle Plate

Location	Loc Qty	Loc Code
WA	10	
58125	7	
58586	3	

D3913-3



Manufactured No

100 Each 1.0000 1

PD 10.06.01

Rib

Location	Loc Qty	Loc Code
WA	1	
58578	1	

D3913-7



Manufactured No

100 Each 0.0000 2

PD 10.06.01
BS3690-2(2)

Rib

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

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Page 2

Work Order ID: 59083



Parent Item: D3913-041



Parent Item Name: Long Basket Base Assembly, 350

Start Date: 5/26/10

Required Date: 6/03/10

Comments: IPP Rev:A new issue DD 10.03.19 verified by:EC
chg qty's DD 10.04.12 verified by:EC

IPP Rev:B

Start Qty: 1.00

Required Qty: 1.00

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
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Picklist Print

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Page 3

Work Order ID: 59083



Parent Item: D3913-041



Parent Item Name: Long Basket Base Assembly, 350

Start Date: 5/26/10

Required Date: 6/03/10

Comments: IPP Rev:A new issue DD 10.03.19 verified by:EC
chg qty's DD 10.04.12 verified by:EC

IPP Rev:B

Start Qty: 1.00

Required Qty: 1.00

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

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Page 4

Work Order ID: 59083



Parent Item: D3913-041



Parent Item Name: Long Basket Base Assembly, 350

Start Date: 5/26/10

Required Date: 6/03/10

Comments: IPP Rev:A new issue DD 10.03.19 verified by:EC
chg qty's DD 10.04.12 verified by:EC

IPP Rev:B

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D4034-041		Manufactured	No			100	Each	5.0000	1	1		SD 10.06.01	

Aft Upper Rib Assembly

Location	Loc Qty	Loc Code
WA	5	
58141	2	
58696	3	

D4034-043

Manufactured

No

100 Each 3.0000 1



SD 10.06.01

Fwd Upper Rib Assembly

Location	Loc Qty	Loc Code
WA	3	
58697	3	

AN3-10A

Purchased

No

150 Each 60.0000 6



SD 10.06.01

Bolt

Location	Loc Qty	Loc Code
ST351	60	
114330	60	

AN960JD8

NAS1149DN832

Purchased

No

150 Each 0.0000 2



SD 10.06.04

Washer

M 114740

2

SD 10.06.04

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

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May 26, 2010 9:06:43 AM

Work Order ID: 59083



Parent Item: D3913-041



Parent Item Name: Long Basket Base Assembly, 350

Start Date: 5/26/10

Required Date: 6/03/10

Comments: IPP Rev:A new issue DD 10.03.19 verified by:EC
chg qty's DD 10.04.12 verified by:EC

IPP Rev:B

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D2931		Manufactured	No			150	Each	858.0000	2	2			

Bumper

	<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>		
	ST504	858			
	46064	858			

D4021-5

Manufactured

No

150 Each 9.0000 2

2 SB 10/06/04

Blanking Plate

	<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
	ST109	9	
	58140	9	

MS20600-AD4W3

Purchased

No

150 Each 1,785.000 2

1 SB 10/06/04

Cherry Rivets

	<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
	ST321	1785	
	106375	3	
	107939	822	
	111636	960	

MS21042L3

Purchased

No

150 Each 1,722.000 6

2 SB 10/06/04

Nut

	<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
	ST300	1722	
	113537	20	
	113644	202	
	114523	1000	
	114718	500	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

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May 26, 2010 9:06:44 AM

Work Order ID: 59083



Parent Item: D3913-041



Parent Item Name: Long Basket Base Assemby, 350

Start Date: 5/26/10

Required Date: 6/03/10

Comments: IPP Rev:A new issue DD 10.03.19 verified by:EC
chg qty's DD 10.04.12 verified by:EC

IPP Rev:B

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch Purchased	Bin Item No	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
NAS1149F0332P						150	Each	811.0000	12	12			

WASHER



Location	Loc Qty	Loc Code
ST275	811	
18057	811	

12

SB 10/06/04

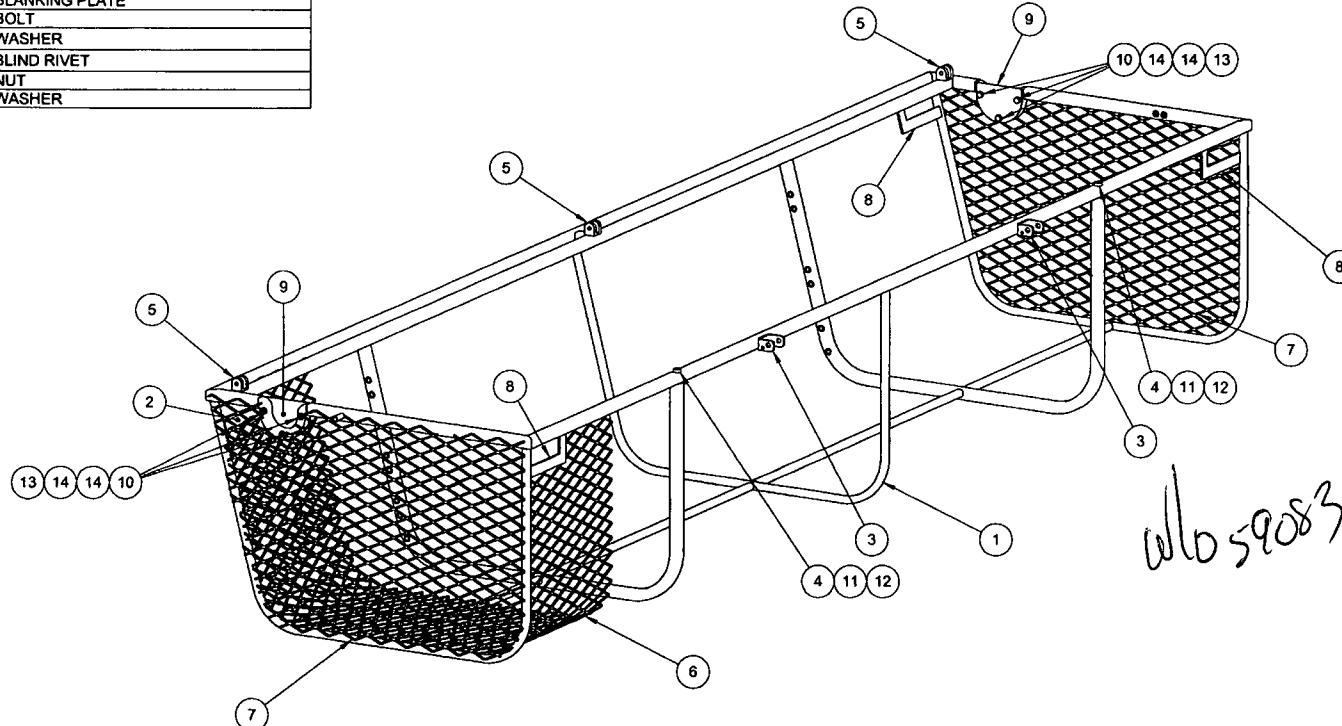
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

ITEM	QTY	P/N	DESCRIPTION
	-041		
	X	D3913-041	LONG BASKET BASE ASSY (350)
1	1	D3913-101	TUBULAR ASSY (350 SHORT BASKET)
2	1	D3913-15	WIDE HANDLE PLATE
3	2	D2581	MOUNTING BRACKET
4	2	D2931	BUMPER
5	3	D4016-1	HINGE HALF, BASE
6	1	D4020-1	MESH (350 BASKET LONG BASE)
7	2	D4020-11	END MESH, BASKET
8	3	D4021-1	HANDLE PLATE
9	2	D4021-5	BLANKING PLATE
10	6	AN3-10A	BOLT
11	2	AN960JD8	WASHER
12	2	MS20600AD4W3	BLIND RIVET
13	6	MS21042L3	NUT
14	12	NAS1149F0332P	WASHER



D3913-041 LONG BASKET BASE ASSY (350)
(MESH SHOWN LOCALLY FOR CLARITY)

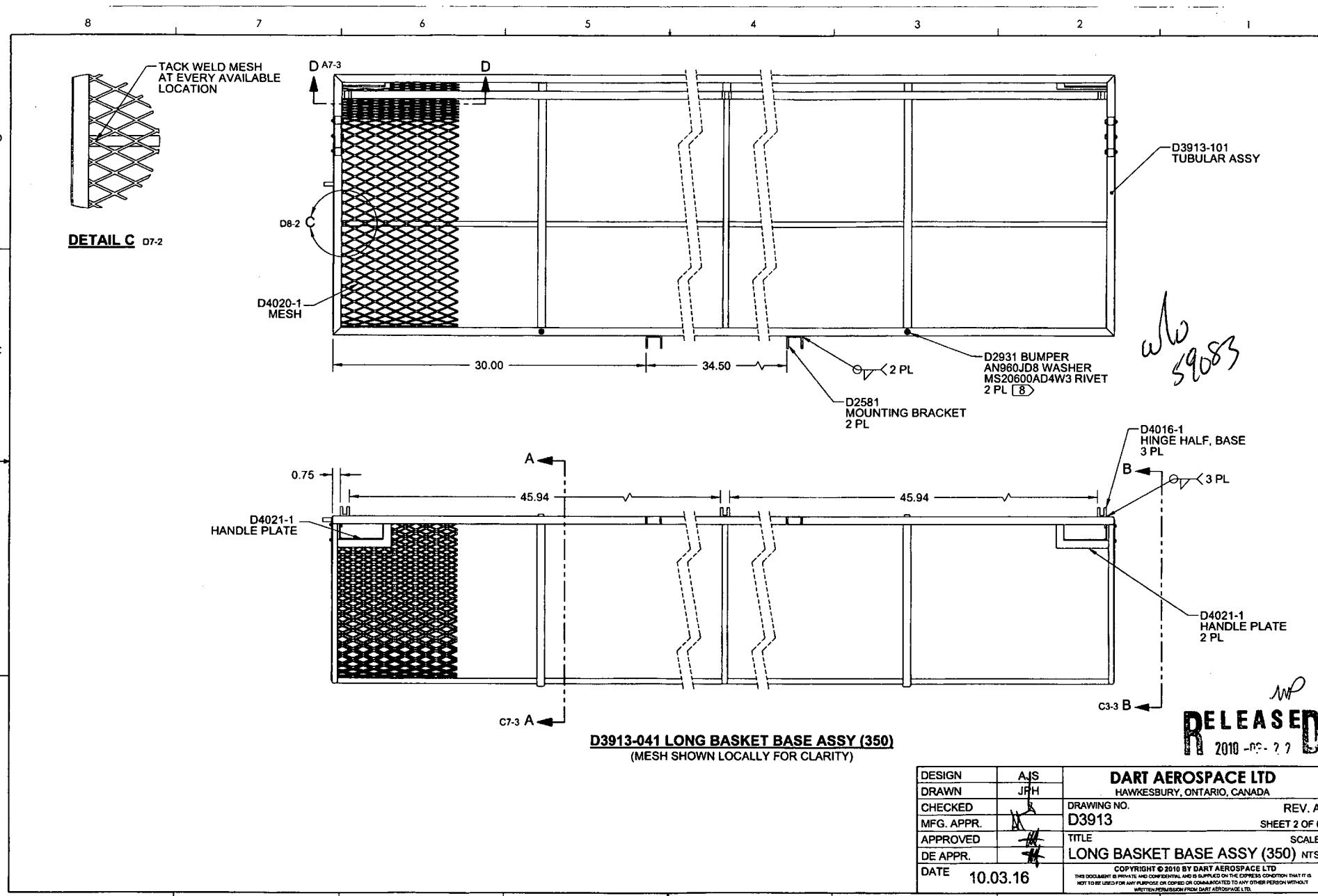
NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: POWDER COAT WHITE (4.3.5.2) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 43.3 lbs APPROX
- 8) INSTALL AFTER FINISH
- 9) MASK HOLES PRIOR TO POWDER COAT
- 10) WELD PER DART QSI 004

A	NEW ISSUE	JPH	10.03.16
REV.	DESCRIPTION	BY	DATE
DESIGN	AJS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	JPH		
CHECKED	W		
MFG. APPR.	W		
APPROVED	W		
DATE	10.03.16		
DRAWING NO. D3913		REV. A	SHEET 1 OF 6
TITLE LONG BASKET BASE ASSY (350) NTS		SCALE	

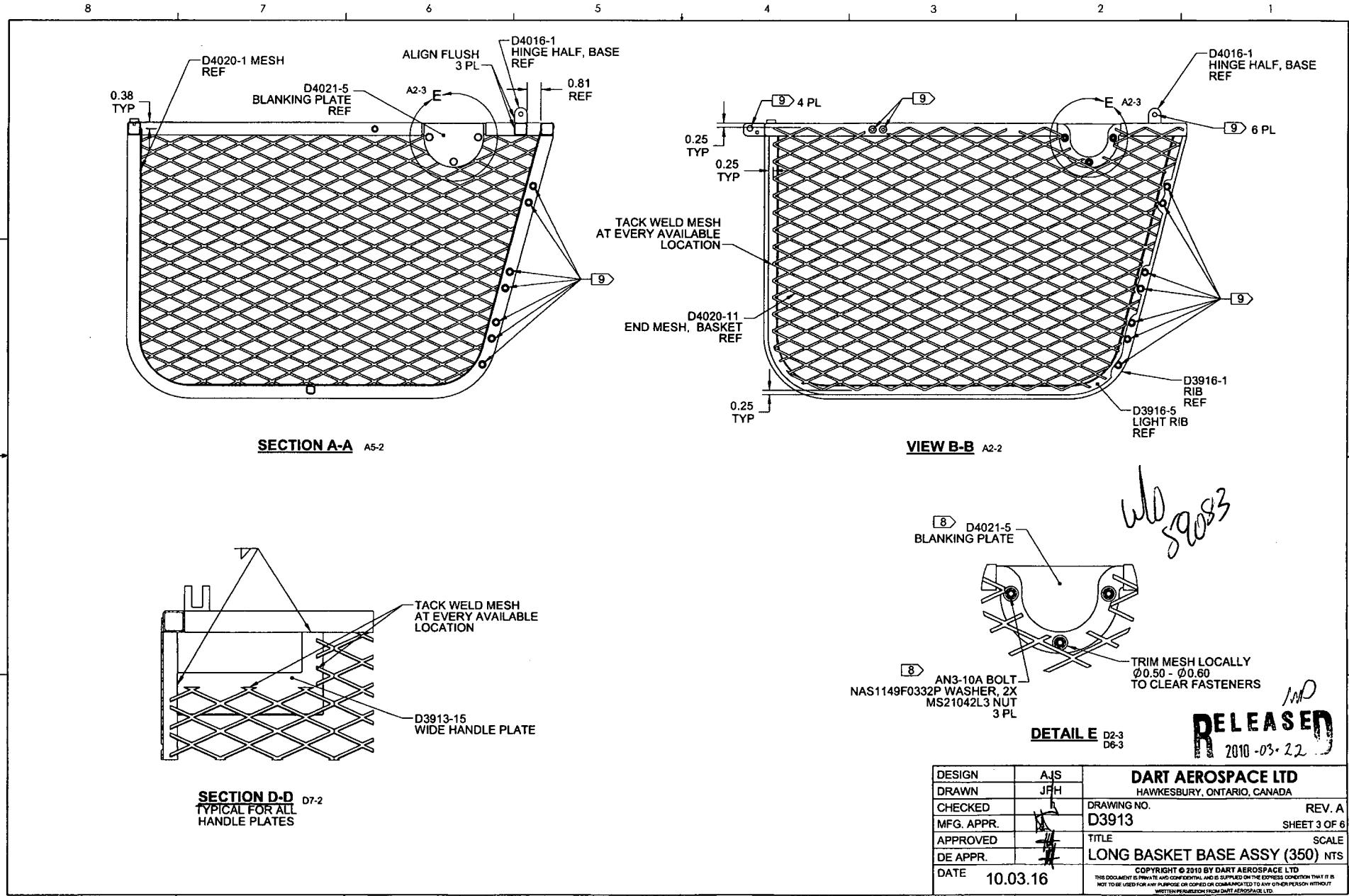
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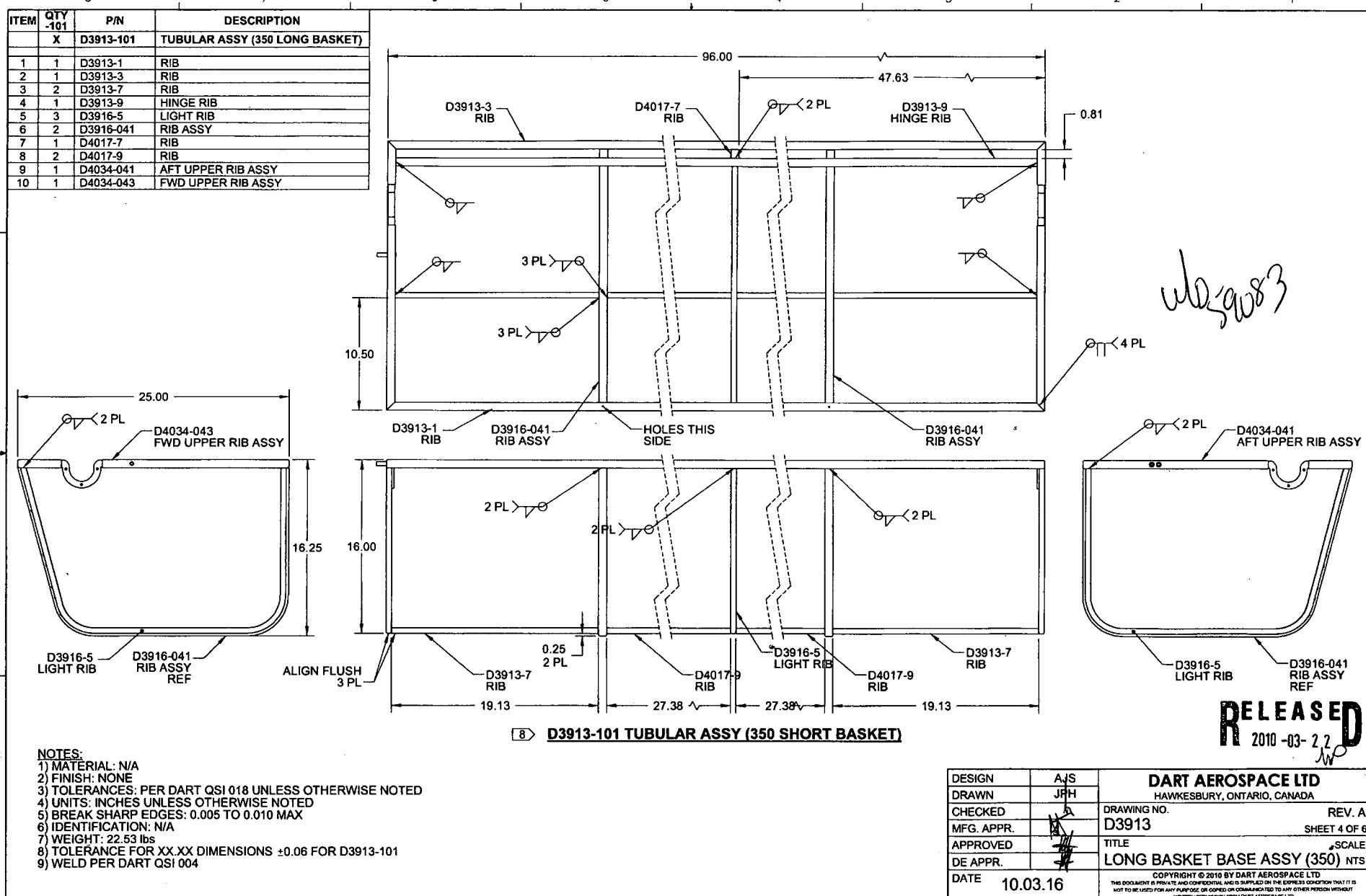
RELEASED
2010-03-22
WJD



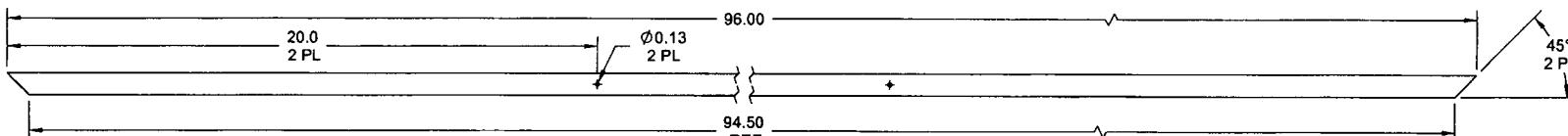
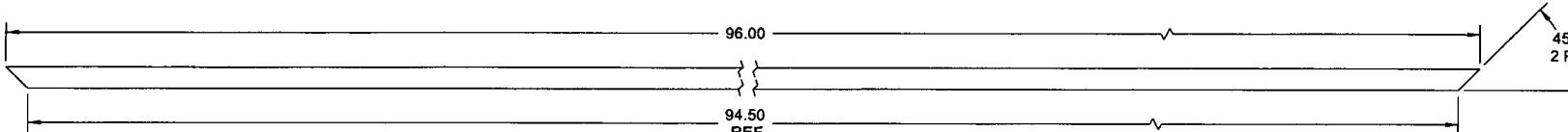
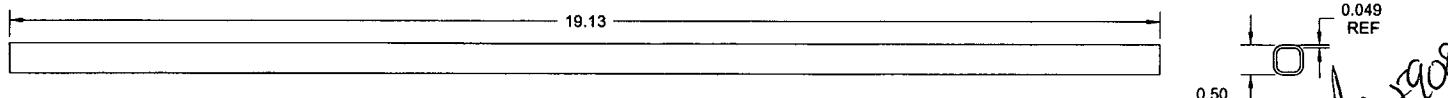
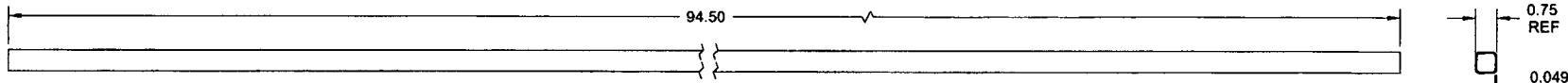
DESIGN	AJS	DART AEROSPACE LTD HAWKSBURY, ONTARIO, CANADA
DRAWN	JRH	
CHECKED		DRAWING NO.
MFG. APPR.		D3913
APPROVED		REV. A
DE APPR.		SHEET 2 OF 6
DATE	10.03.16	SCALE
		LONG BASKET BASE ASSY (350) NTS

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8 7 6 5 4 3 2 1

D3913-1 RIBD3913-3 RIBD3913-7 RIBD3913-9 HINGE RIB

NOTES:

1) MATERIAL -1, -3, -9: AISI 304/316 STAINLESS STEEL SQUARE TUBE, 0.75 X 0.75 X 0.049 WALL
REF DART SPEC. M304TS0.750W.049

-7: AISI 304/316 STAINLESS STEEL SQUARE TUBE, 0.50 X 0.50 X 0.049 WALL
REF DART SPEC. M304TS0.500W.049

2) FINISH: NONE
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
6) IDENTIFICATION: N/A
7) WEIGHT: SEE ASSEMBLED WEIGHTS

8 7 6 5 4 3 2 1

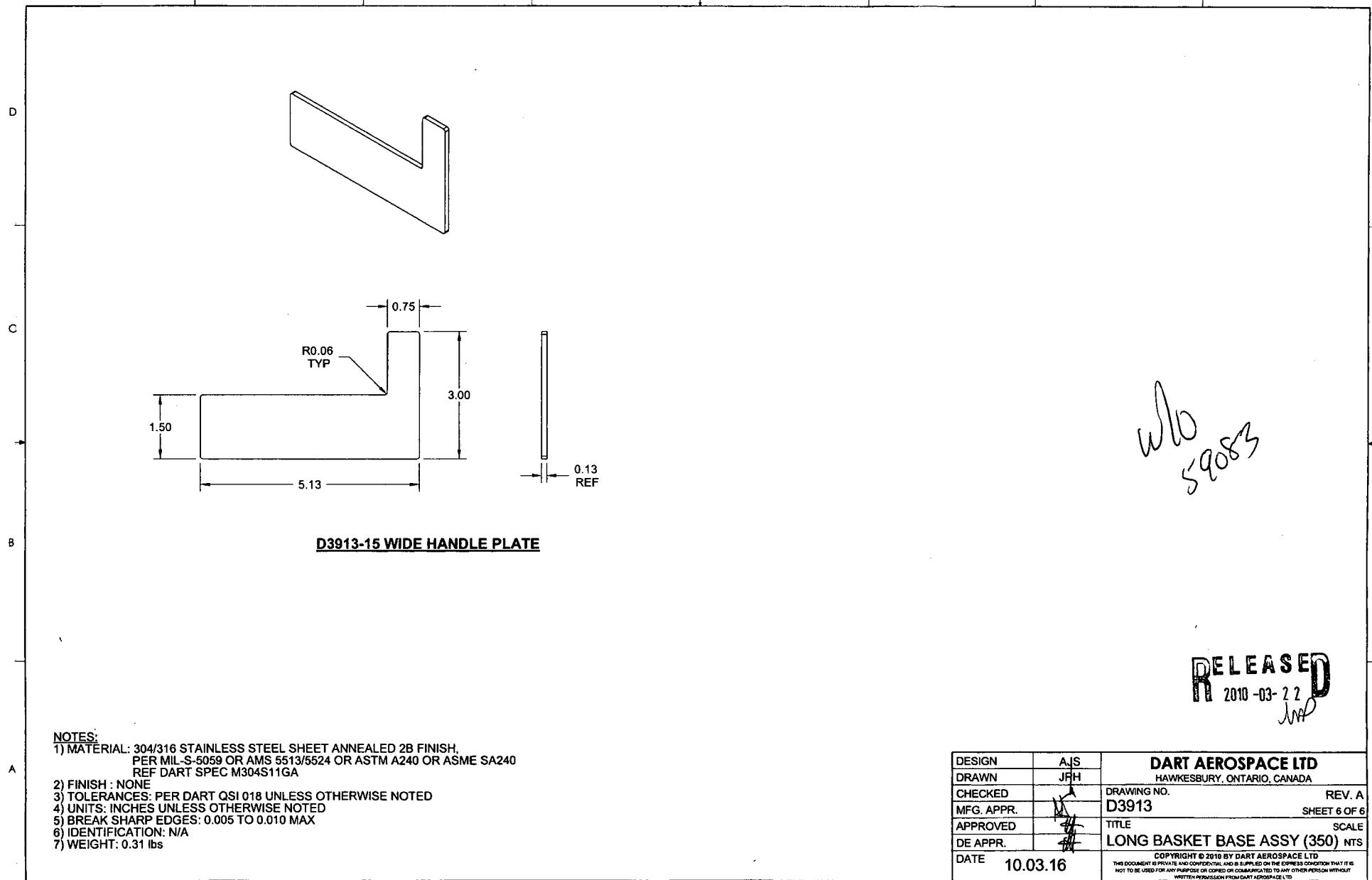
RELEASED
2010-03-22

DESIGN	A/S	DART AEROSPACE LTD
DRAWN	JPH	HAWKESBURY, ONTARIO, CANADA
CHECKED		DRAWING NO.
MFG. APPR.		REV. A
APPROVED		D3913
DE APPR.		SHEET 5 OF 6
DATE	10.03.16	SCALE
		LONG BASKET BASE ASSY (350) NTS

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A

8 7 6 5 4 3 2 1



8 7 6 5 4 3 2 1